



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3812**Job Sheet 206319****Part No:** 646.3812**Job Qty:** 24 pcs**Part Name:** Gusset Bracket**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 1/29/20**Job Tracking No:****Due Date:** 3/9/20**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG 646.3800 REV.A IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD IPP REV:B 18.07.03 AS PER
DWG REV.A DD VERF:JFS

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	24 pcs			0.00	1.20	Bandsaw - 1		<i>W 20/2/4</i>
110	Conventional Mill - 1 - B4B	24 pcs			0.00	3.64	Conventional Mill - 1 - B4B		
							Conventional Mill - 2 - B4B		<i>W 20/2/5</i>
120	QC 2	24 pcs			0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S253237**Part:** 646.3812**Job No:** 206319**Serial No/Batch:** S253237**Revision:** Rev A**Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 02/04/20

44"
72" x 5

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130 QC 8	24 pcs	0.00 0.00	QC 2 - 63	20/2/15	
			QC 2 - 8		
			QC 2 - 66		
			QC 2 - 64		
			QC 2 - 65		
			QC 2 - 5		
			QC 2 - 71		
			QC 2 - 73		
			QC 2 - 69		
			QC 2 - 76		
			QC 8 - 12		
			QC 8 - 14		
			QC 8 - 17		
			QC 8 - 20		
			QC 8 - 25		
			QC 8 - 3		
			QC 8 - 32		
QC 8 - 33					
QC 8 - 35					
QC 8 - 39					
QC 8 - 4					
QC 8 - 44					
QC 8 - 45					
QC 8 - 49	mmL / JSP 20-02-05				
QC 8 - 58					
QC 8 - 8					
QC 8 - 9					
QC 8 - 68					
QC 8 - 67					
QC 8 - 1 (A)					
QC 8 - 47					
QC 8 - 40					
QC 8 - 52					
QC 8 - 23					
QC 8 - 57					
QC 8 - 76					
QC 8 - 61					
140 Outsource - 4 - Anodize		24 pcs		ATG001-VC 8	2020-02-10
150 Packaging 2-1 - Receive - B4B		24 pcs	0.00 0.00	Packaging 2 - 1 - B4B	
			Packaging 2 - 2 - B4B	FEB 24 2020	
			Packaging 2 - 3 - B4B		
			Packaging 2 - 5 - B4B		
			Packaging 2 - 4 - B4B		
			Packaging 2 - 6 - B4B		
			Packaging 2 - 7 - B4B		
			Packaging 2 - 8 - B4B		
			Packaging 2 - 9 - B4B		
			Packaging 2 - 10 - B4B		
			Packaging 2 - 11 - B4B		
			Packaging 2 - 12 - B4B		
			Packaging 2 - 13 - B4B		
			Packaging 2 - 14 - B4B		
			Packaging 2 - 15 - B4B		
			Packaging 2 - 16 - B4B		
			Packaging 2 - 17 - B4B		
			Packaging 2 - 18 - B4B		
			Packaging 2 - 19 - B4B		
			Packaging 2 - 20 - B4B		
			Plex 1/29/20 10:10 AM Dart.lajeunesse.marie		

			Packaging 2 - 21 - B4B	
			Packaging 2 - 22 - B4B	
			Packaging 2 - 23 - B4B	
			Packaging 2 - 24 - B4B	
			Packaging 2 - 25 - B4B	
			Packaging 2 - 26 - B4B	
			Packaging 2 - 27 - B4B	
			Packaging 2 - 28 - B4B	
			Packaging 2 - 29 - B4B	
			Packaging 2 - 30 - B4B	
			Packaging 2 - 31 - B4B	
			Packaging 2 - 32 - B4B	
			Packaging 2 - 33 - B4B	
			Packaging 2 - 34 - B4B	
			Packaging 2 - 35 - B4B	
			Packaging 2 - 36 - B4B	
			Packaging 2 - 37 - B4B	
155	QC 6	24 pcs	0.00 0.00	QC 6 - 9
				QC 6 - 68
				QC 6 - 61
				QC 6 - 40
				QC 6 - 81
				DAS 81
				9-89
				APR 14 2020
180	Packaging 3-1 - Stock - B4B	24 pcs ✓	0.00 0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B
				Packaging 3 - 3 - B4B ✓
				Packaging 3 - 4 - B4B
				Packaging 3 - 5 - B4B
				Packaging 3 - 6 - B4B
				Packaging 3 - 7 - B4B
				Packaging 3 - 8 - B4B
				Packaging 3 - 9 - B4B
				Packaging 3 - 10 - B4B
				Packaging 3 - 11 - B4B
				Packaging 3 - 12 - B4B
				Packaging 3 - 13 - B4B
				Packaging 3 - 14 - B4B
				Packaging 3 - 15 - B4B
				Packaging 3 - 16 - B4B
				Packaging 3 - 17 - B4B
				Packaging 3 - 18 - B4B
				Packaging 3 - 19 - B4B
				Packaging 3 - 20 - B4B
				Packaging 3 - 21 - B4B
				Packaging 3 - 22 - B4B
				Packaging 3 - 23 - B4B
				Packaging 3 - 24 - B4B
				Packaging 3 - 25 - B4B
				Packaging 3 - 26 - B4B
				Packaging 3 - 27 - B4B
				Packaging 3 - 28 - B4B
				Packaging 3 - 29 - B4B
				Packaging 3 - 30 - B4B
				Packaging 3 - 31 - B4B
				Packaging 3 - 32 - B4B
				Packaging 3 - 33 - B4B
				Packaging 3 - 34 - B4B
				Packaging 3 - 35 - B4B
				Packaging 3 - 36 - B4B
				Packaging 3 - 37 - B4B

190 QC 21 - SA	24 ☒ pcs	0.00 0.00	QC 21 - SA - 21 ☒	DAS	CCK105
			QC 21 - SA - 70	21	
			QC 21 - SA - 53	9-09	APR 14 2020

Part Op 100 - Bandsaw
 Descriptions: 110 - Manufacture as per dwg - 1-Machine per DWG
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Issue P/O to ATG: 45819 AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required
 150 - Receive & Inspect for Damage & Mat'l Certs
 180 - Identify as per dwg & Stock Location: ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 190 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M7075T6A0.75X0.75X0.060X0.062	7075T6 Angle .75" X .75" X .060" X .062"W	4.3200 ft (.18 ea)	100-Bandsaw - 1	S177700

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6A0.75X0.75X0.060X0.062	4	38	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Gusset Bracket	2.000Inches ± 0.010	2.010 1.990		Vernier JWS
2	Gusset Bracket	0.060Inches ± 0.010	0.070 0.050		"
3	Gusset Bracket	0.750Inches ± 0.010	0.760 0.740		"
4	Gusset Bracket	0.060Inches ± 0.010	0.070 0.050		"
5	Gusset Bracket	0.310Inches ± 0.010	0.320 0.300		"
6	Gusset Bracket	0.060Inches ± 0.010	0.070 0.050		"
7	Gusset Bracket	0.380Inches ± 0.010	0.390 0.370		"
8	Gusset Bracket	1.250Inches ± 0.010	1.260 1.240		"
9	Gusset Bracket	0.090Inches ± 0.010	0.100 0.080		"

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045819



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-André

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045819

PO Date: 2/10/20

Due Date: 2/26/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

2020-02-14

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	206132	D5155-043	D5155 Rev B	Co-Pilot Collective Head Assembly (212/412) : Various STC's Anodize Black as per Dwg D5155 Rev. B	Firmed	-	2/26/20	2 pcs	0 pcs	2 pcs	\$6.54/pcs	\$13.08
2	206132	SWA6A-800A	SWA6A-800A Rev 4	Connector Bushing -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1 WATER SEAL As Per Dwg SWA6A800 Rev. 4 - Certificate of Conformity is required	Firmed	-	2/26/20	30 pcs	0 pcs	30 pcs	\$4.09/pcs	\$122.70



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PURCHASE ORDER

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Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	206319	646.3812	646.3800 Rev A	Gusset Bracket : Various STC's Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed <i>K94</i>	-	2/26/20	24 pcs	0 pcs	24 pcs	\$6.89/pcs	\$165.36

FEB 24 2020

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PURCHASE ORDER

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Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	206318	646.3810	646.3800 Rev A	Bracket : Various STC's Issue P/O to ATG: AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP- 172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed <i>X23</i>	-	2/26/20	24 pcs	0 pcs	24 pcs	\$7.34/pcs	\$176.16
FEB 24 2020												
5	206391	RBT18591- 7	RBT18591 Rev 2B	Vise Fixture (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed <i>X6</i>	-	2/26/20	6 pcs	0 pcs	6 pcs	\$9.79/pcs	\$58.74
FEB 18 2020												



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PURCHASE ORDER

POHB045819



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	204984	647.0210	647.0200 Rev N/C	Rail : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP- 172 SECTION 4.2, PRIME AS PER IAW MIL- PRF-23377 TYPE 1 CLASS N	Firmed <i>x16</i>	-	2/26/20	16 pcs	0 pcs	16 pcs	\$11.29/pcs	\$180.64 <i>KE</i>
FEB 24 2020												



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PURCHASE ORDER

POHB045819



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	204979	647.0111	647.0100 Rev B	Panel : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	-	2/26/20	16 pcs	0 pcs	16 pcs	\$40.04/pcs	\$640.64
8	206316	646.3715	646.3700 Rev A	Strut Doubler : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed X40	-	2/26/20	40 pcs	0 pcs	40 pcs	\$7.04/pcs	\$281.60

FEB 24 2020

Grand Total: \$1,638.92

Signature



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PURCHASE ORDER

POHB045819



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

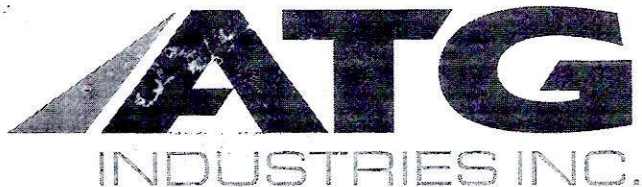
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/14/20 2:33 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919631

Date: 21-Feb-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

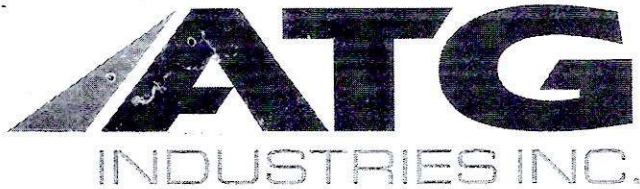
Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
24 ea	Part: 646.3812 Gusset Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot #: 5236137 Job: 26932 PO: POHB045819		Rev: A Expiry Date: 05/29/2021 Line: 3
23 ea	Part: 646.3810 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# 5236137 Job: 26933 PO: POHB045819		Rev: A Expiry Date: 05/29/2021 Line: 4
16 ea	Part: 647.0111 Panel Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5236137 Job: 26936 PO: POHB045819		Rev: B Expiry Date: 05/29/2021 Line: 7
Made in Canada.			

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FEB 21 2020
DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919631

Date: 21-Feb-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
40 ea	Part: 646.3715 Strut Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5236137 Job: 26937 PO: POHB045819	Rev: A	Expiry Date: 05/29/2021 Line: 8
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: FEB 21 2020 Certified Signature: <i>[Signature]</i> Receiver Signature: <i>[Signature]</i> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. RECEIVED FEB 21 2020 DART AEROSPACE LTD.			

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